

Date: Tuesday, 11/22/2005 4:58:47 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 24942		
Estimate Number	: 10310		
P.O. Number	: N/A	Part Number	: D26175
This Issue	: 11/22/2005 S.O. No. : N/A	Drawing Number	: D2617 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/22/2005 Type : MACHINED PARTS	Drawing Revision	: D2
Previous Run	: 24401	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/2/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	60 Um: Each
Comment	: Est H 04.07.14 Reformat; added step 5 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.0205 f(s)/Unit Total: 1.2285 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch M17267gml 05/11/27

60

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA438 and Dwg D2617

Ø0.500" tubing x 0.058" wall

gml 05/11/27

60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

gml 05/11/27

60

4.0	QC8	SECOND CHECK <u>5.1</u>
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Comment: SECOND CHECK

SAD 05/11/27

60

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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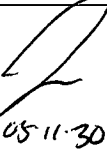
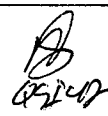
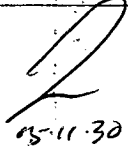
Comment: Deburr break all unmarked sharp edges 0.005 to 0.010

DL 05/11/30

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: SD Date: 05/12/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-30	5	1 part deburred to much on the side		scrap - destroy	 05-11-30	 05-11-30		 05-11-30

NOTE: Date & initial all entries

Date: Tuesday, 5/22/2005 4:58:47 PM

User: Linda B

## Process Sheet

Customer: CUBA 001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 24942

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

7 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

M/ 05/12/01 59

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 05/11/30 59

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05/12/01 59

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

10 5/12/01 59

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/05 59

05/12/02

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

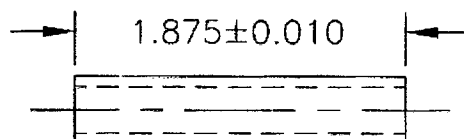
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

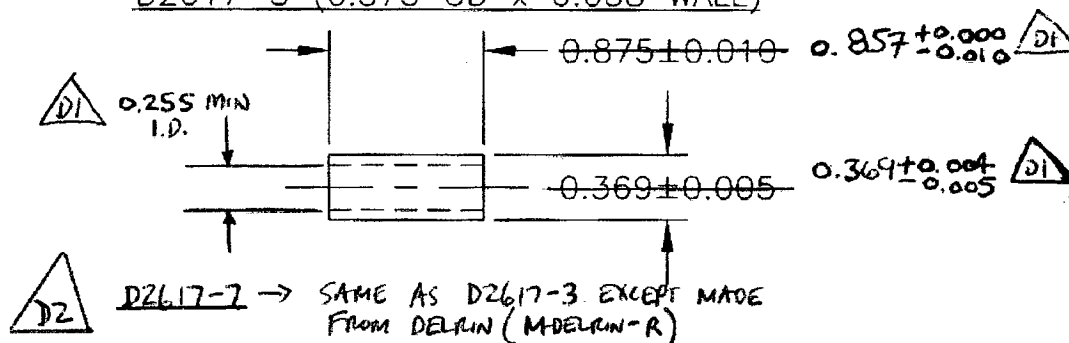


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.09.10	#	CP	ADD D2617-7	
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
D1	CP	04.07.12	#	CORRECT TOLERANCE (NCR 779)	

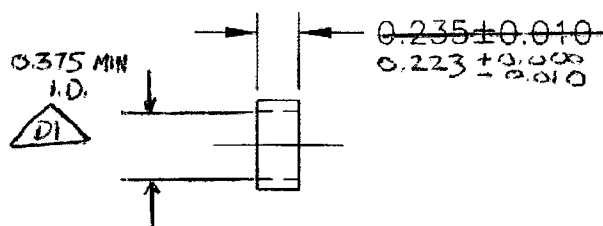
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05

#### NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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